

Work Order ID 68168

Thursday, April 07, 2011 12:10:15 PM



Page 1

Item ID: D3552-28 *21*

Accept



Setup Start



Revision ID:

Item Name: Door Prop

Start Date: 4/7/2011 Start Qty: 1.00



Required Date: 4/7/2011 Req'd Qty: 1.00



Cust Item ID:

Customer:

**PRELIMINARY
ISSUE**

Stop



Reference:

Approvals:

Process Plan: *CL*Date: *11/04/07*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3552

PH2

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: *13824*

Purchase Part Number: B6-167-408-070N

Supplier: LS Technologies

Certificate of conformity is required

CL 11/04/07 (1)

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure certificate of conformity is attached

CL 11/4/13 (1)

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Test for correct pressure

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 68168

Thursday, April 07, 2011 12:10:15 PM

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Item ID: D3552-23 *21* Accept  Setup Start 
Revision ID: Stop 
Item Name: Door Prop
Start Date: 4/7/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 4/7/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
			<i>ship direct to Eagle</i> <i>attn: Dana Campbell</i>						
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

CL1104119

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, April 07, 2011 12:10:12 PM

Work Order ID: 68168

Parent Item:

D3552-23

Parent Item Name: Door Prop



Start Date: 4/7/2011


Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:A 11.04.07 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
B6-167-408-070N  CARBON STEEL GAS SPRING		Purchased	No			110	Each	0.0000	1	1			

Picklist

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



Work Order ID 68168

Thursday, April 14, 2011 9:56:57 AM





Page 1


Item ID: D3552-21 ~~#~~ Accept  Setup Start 
Revision ID:
Item Name: Door Prop Stop 
Start Date: 4/7/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 4/7/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3552	G								

100  PURCHASING 0.00
Purchasing Memo 0.00
Purchasing Issue P/O: 410
Purchase Part Number: B6-167-408-070N
Supplier: LS Technologies
Certificate of conformity is required

110  Receive & Inspect for Damage & Mat'l Certs 0.00
Packaging Memo 0.00
Packaging Ensure certificate of conformity is attached

120  QC6- Inspect dimensions to drawing 0.00 ~~#~~ 11.04.19
QC Memo 0.00
Quality Control Test for correct pressure

Work Order ID 68168

Thursday, April 14, 2011 9:56:57 AM



Page 2

Item ID: D3552-25 21 #

Revision ID:

Item Name: Door Prop

Start Date: 4/7/2011 Start Qty: 1.00

Required Date: 4/7/2011 Req'd Qty: 1.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

CL11/04/19



303 - 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

1 Unit: B6-167-410-070N Gas Spring (D3552-23) Carbon Steel Gas Spring

-21 ~~11~~ 11.04.19

Country of Manufacture: Canada

Date of Manufacture : April 2011

This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 13824

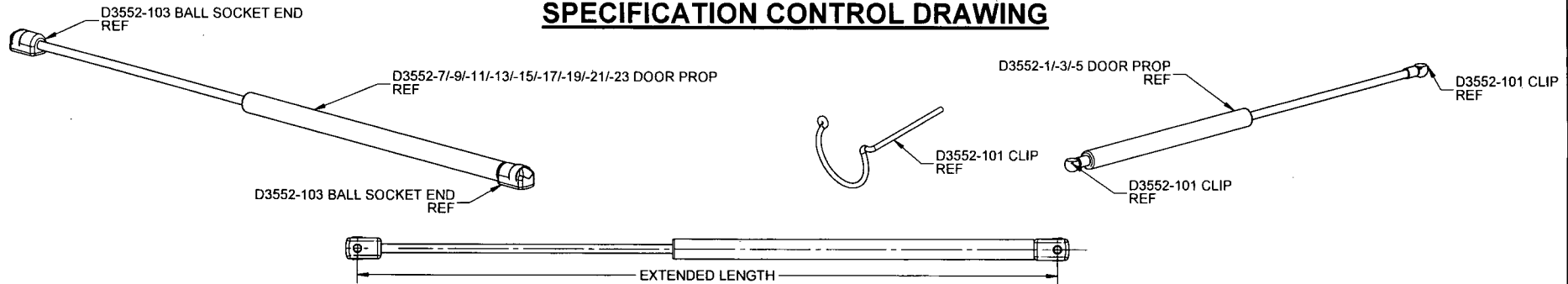
Invoice # 7153

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to read "Nolan Fehr", written over a horizontal line.

Nolan Fehr
Manager

8 7 6 5 4 3 2 1 **SPECIFICATION CONTROL DRAWING**



DART PART NUMBER	DESCRIPTION	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	FORCE (N/lb)	END FITTING	MATERIAL	SUPPLIER	SUPPLIER PART NUMBER OR MODEL NUMBER	ALTERNATE SUPPLIER	ALTERNATE SUPPLIER P/N OR MODEL NUMBER
D3552-1	DOOR PROP	220/8.66	530/20.6	70/15.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-220-530-070N	N/A	N/A
D3552-3	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-200-490-200N	N/A	N/A
D3552-5	DOOR PROP	175/6.89	430/16.9	150/33.7	10mm SS BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	C8-175-430-150N	N/A	N/A
D3552-7	DOOR PROP	220/8.66	530/20.9	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-220-530-070N	N/A	N/A
D3552-9	DOOR PROP	200/7.87	490/19.3	200/45.0	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-200-490-200N	N/A	N/A
D3552-11	DOOR PROP	240/9.45	575/22.6	150/33.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-240-575-150N	N/A	N/A
D3552-13	DOOR PROP	220/8.66	530/20.9	140/31.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-220-530-140N	N/A	N/A
D3552-15	DOOR PROP	139/5.47	386/15.2	300/67.4	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-300N	SUSPA, Inc.	16-2-210-139-A101-B101-400N
D3552-17	DOOR PROP	139/5.47	386/15.2	156/35.1	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-156N	SUSPA, Inc.	16-2-210-160-A101-B101-156N
D3552-19	DOOR PROP	139/5.47	386/15.2	60/13.5	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B8-154-387-060N	SUSPA, Inc.	16-2-210-139-A101-B101-060N
D3552-21	DOOR PROP	200/7.87	490/19.3	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-200-490-070N	N/A	N/A
D3552-23	DOOR PROP	167/6.57	408/16.1	70/15.7	10mm NYLON BALL SOCKET	CARBON STEEL	LS TECHNOLOGIES	B6-167-408-070N	N/A	N/A
D3552-101	CLIP	N/A	N/A	N/A	N/A	CARBON STEEL	LS TECHNOLOGIES	C9	N/A	N/A
D3552-103	BALL SOCKET END	N/A	N/A	N/A	N/A	NYLON	LS TECHNOLOGIES	B10	N/A	N/A

D3552-X DOOR PROP

PRELIMINARY ISSUE

11.03.10

NOTES:

- 1) IDENTIFICATION: IDENT P/N D3552-X & B/N PER QSI 044 6.2
- 2) D3552-101 CLIP IS ONLY COMPATIBLE WITH D3552-1/-3/-5 DOOR PROPS
- 3) D3552-103 BALL SOCKET END IS ONLY COMPATIBLE WITH D3552-7/-9/-11/-13/-15/-17/-19/-21/-23 DOOR PROPS

PH-2	ADD P/N D3552-21/-23	DC	11.03.10
G	FOR -15, FORCE:300/67.4 WAS 400/89.9, SUPPLIER P/N B8-154-387-300N WAS B8-154-387-400N; FOR -17, STROKE: 139/5.47 WAS 160/6.30, EXT LG: 386/15.2 WAS 407/16.0, SUPPLIER P/N B8-154-387-156N WAS B8-167-408-156N	JPH	10.11.01
F	ADD P/N D3552-15/-17/-19 AND ALTERNATE SUPPLIER	JPH	10.07.27
E	ADD P/N D3552-13 ZN B8-1, A8-1, D6-1, CHANGE NAME FROM "GAS SPRING" TO "DOOR PROP" THROUGH OUT DWG	HS	10.02.03
D	ADD P/N D3552-101 ZN D6-1, C7-1, C1-1 AND D3552-103 ZN D1-1 AND C2-1 AND ZN B8-1; ADD NOTE REGARDING D3552-101 AND D3552-103 COMPATIBILITY ZN A8-1	HS	09.04.02
C	ADD D3552-11 AND CONVERSIONS FOR INSPECTION; UPDATE P/N FOR D3552-7	LE	07.06.01
B	ADD D3552-7/-9; UPDATE DESC. D3552-1/-3/-5	LE	06.10.24
A	NEW ISSUE	LE	06.09.15
REV.	DESCRIPTION	BY	DATE
DESIGN	CE		
DRAWN	DC		
CHECKED	AB		
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	11.03.10		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3552** REV. PH-2
SHEET 1 OF 1
TITLE **DOOR PROP** SCALE NTS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO13824**

Purchase Order Date 4/7/2011
PO Print Date 4/7/2011

Page Number 1 of 1

Order From : VC-LST0001
LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	306 683 5000	Requisition Nbr	
Vendor Fax	306 683 6403	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

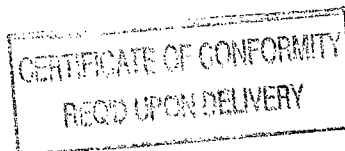
Ship To : EAGLE COPTER 823 MCTAVISH
CALGARY, AB
CANADA

FAXED
4/11/2011

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	B6-167-408-070N	CARBON STEEL GAS SPRING	4/7/2011 Yes	1.00 Each		\$32.5000	\$32.50

Special Inst: AS PER DWG D3552 REV. G
B68168
PLEASE SHIP DIRECT TO EAGLE
COPTERS
ATTN: DANIEL CAMPBELL

PO Total: \$32.50



Uc2

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 4/7/2011

LS Technologies Canada Inc.
303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Invoice

Date	Invoice #
4/7/2011	7153

Invoice To
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Eagle Copters 823 McTavish Road Calgary, AB T2E 7G9 Att: Dan Campbell

P.O. No.	Terms	Rep	Ship Via
PO13824	Net 30	Nolan	Fed-Ex

Description	Qty	Rate	Amount
B6-167-410-070N Gas Spring (D3552-23)	1	32.50	32.50
Shipping Via FED EX to Eagle Copters Tracking #796961972315		0.00	0.00
Please Pay by Invoice: No Statement Issued.		GST/HST	CAD 4.23

ALL RETURNED GOODS REQUIRE PRIOR APPROVAL & RMA # .RETURNS
WITHOUT AN RMA# WILL NOT BE ACCEPTED OR CREDITED
Interest charges of 2% per month on overdue accounts.
We appreciate your business. Thank you !

Total	CAD 36.73
--------------	-----------

Phone #	Fax #	LS Technologies E-mail
(306) 683-5000	(306) 683-6403	info@lstechnologies.ca

GST/HST No. 875007718



303 – 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Compliance

This is to certify that the parts listed below meets specifications as required by your order.

1 Unit: B6-167-410-070N Gas Spring (D3552-23) Carbon Steel Gas Spring

Country of Manufacture: Canada

Date of Manufacture : April 2011

This product is ROHS compliant.

We certify no mercury was used in the manufacture of this order.

Purchase Order # 13824

Invoice # 7153

L S Technologies Inc Canada

Nolan Fehr
Manager